

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013212**Date Inspected:** 05-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Geng wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#14

SMAW welding of weld joint 4G-010,009 located on PCMK SEG071A of 11DW welder is identified as 047864, 045268.ZPMC QC is identified as Mr.Xu tao . The welding variables recorded by QC appeared to Comply with the WPS-B-P-2214-Tc-U4b-FCM-1.

SMAW welding of weld joint 4G-026 located on PCMK SEG071A of 11DW welder is identified as 037723. ZPMC QC is identified as Mr.Xu tao . The welding variables recorded by QC appeared to Comply with the WPS-B-P-2214-Tc-U4b-FCM-1.

FCAW welding of weld joint 2G-003 located on PCMK CA3011 of 12CW welder is identified as 201215.ZPMC QC is identified as Mr.Xu tao . The welding variables recorded by QC appeared to Comply with the WPS-B-T-2231-Tc-U4b-F.

This QA inspector performed in process Visual Inspection of the below mentioned complete joint penetration weld between bottom plate and side plate of segment 12CW. During in process visual inspection of the above mentioned weld after back gouging and grinding, this QA observed one (1) transverse indication. SEG3006A-002.

- This was confirmed with MT wherein, One (1) transverse crack measuring approximately 8 mm length.

- This weld was previously Magnetic Particle Testing (MT) tested and accepted by ZPMC Quality Control (QC)

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personnel after back gouging.

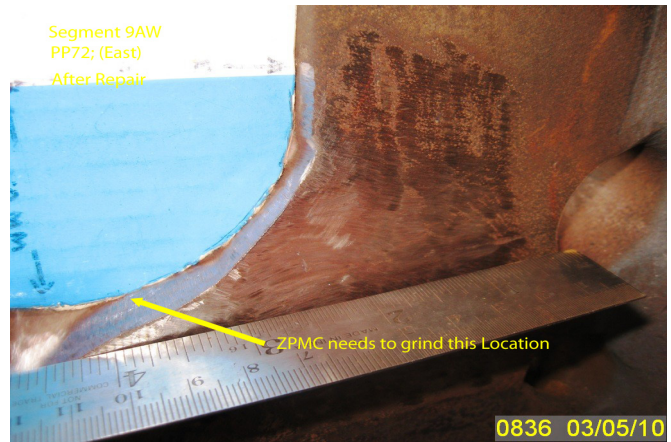
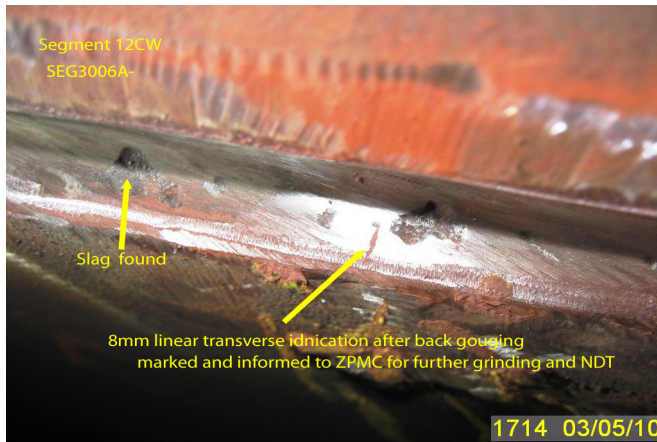
- This is informed to ZPMC QC for further grinding and future NDT follow-up before welding. No incident report written for this incident.

OUTSIDE SHOP

This QA inspector performed dimensional check, size and smoothness of cope hole in segment 9AW. Marked the locations where we need some grinding for ZPMC future repair work.

Repair work of Floor beam shear plate (X7) excess trimmed edge radius measured, but ZPMC need to some more grinding. Checked with template and informed to ABF QA Mr.Liaho.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Chadra	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
